

FIG. 9



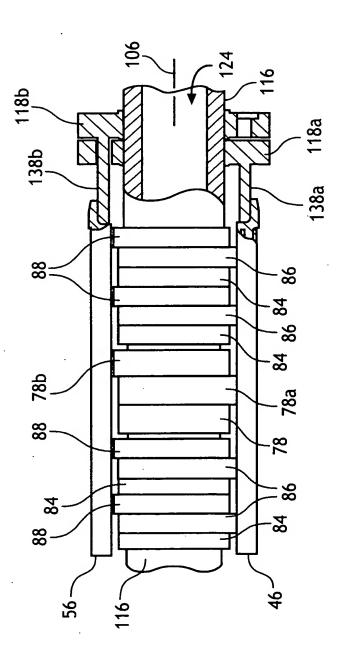


FIG. 10

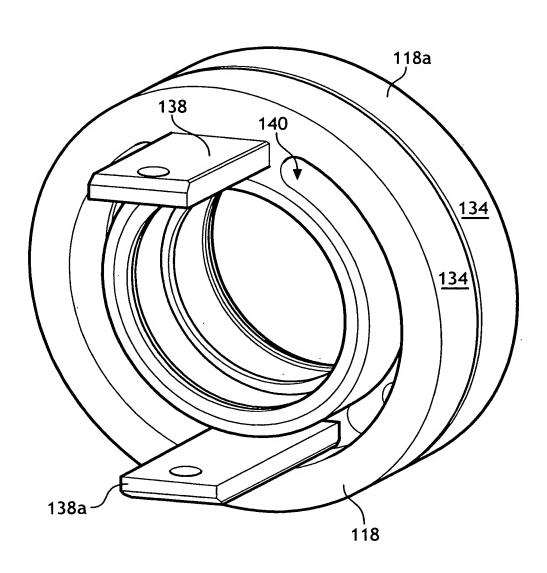
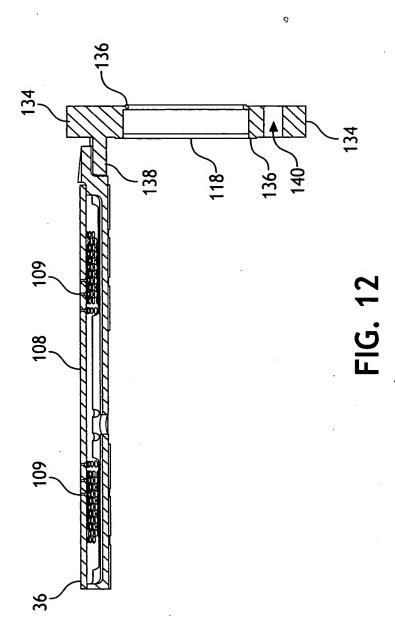
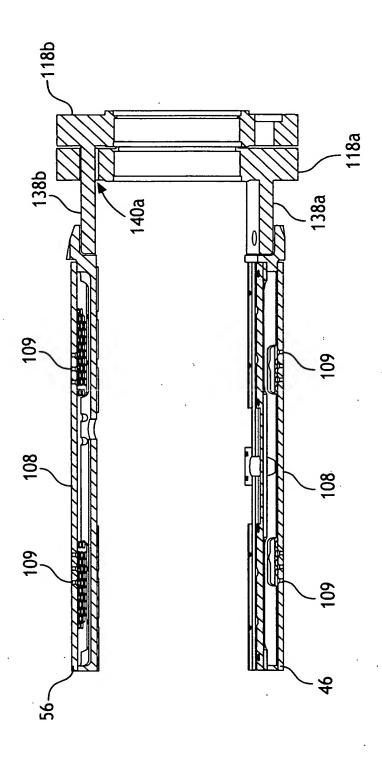


FIG. 11

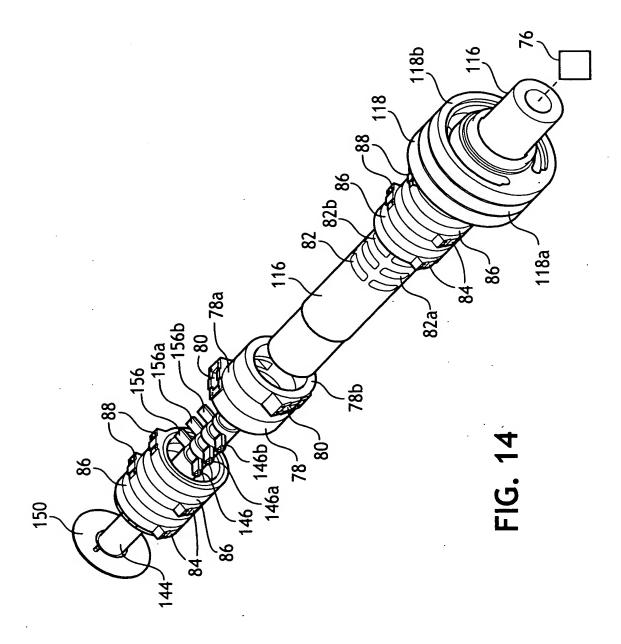




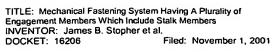








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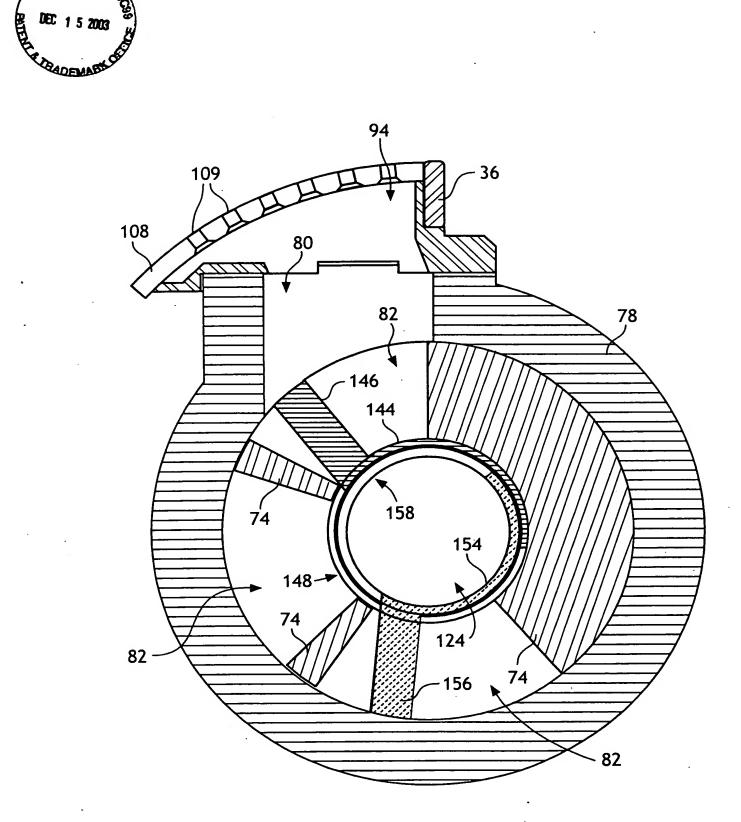
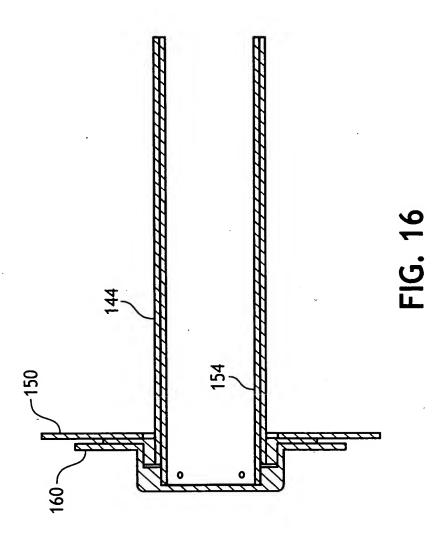


FIG. 15





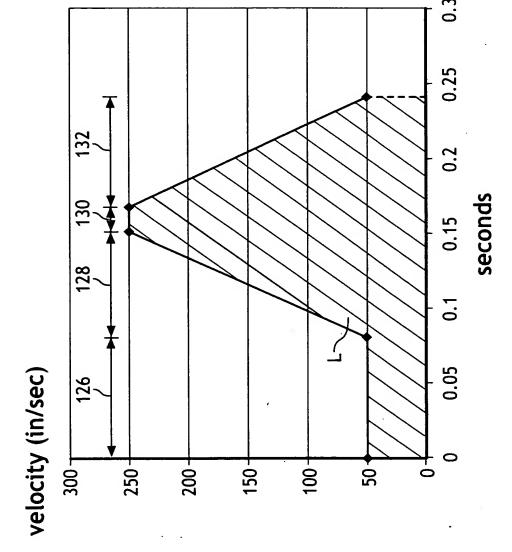


FIG. 17



## **Speed Profile Data**

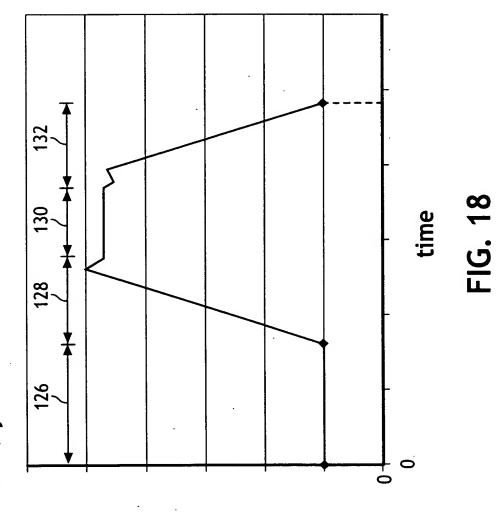
	Time (sec)	Velocity (in/sec)
V1 start	0	50
V1 end	0.08	50
V2 start	0.152	250
V2 end	0.168	250
cycle end	0.24	50

**FIG. 17A** 

	Speed (inch/sec)	start time	end time	Interval (seconds)	Motion-area (inch)
Low-speed (V1)	50	0	0.08	0.08	4
Acceleration		0.08	0.152	0.072	10.8
High Speed (V2)	250	0.152	0.168	0.016	4
Deceleration		0.168	0.24	0.072	10.8
					29.6 Total

FIG. 17B





velocity